

Work Order ID 51170

August 6, 2009 9:19:45 AM



Page 1

Item ID: D3929-041

Accept



Setup Start



Revision ID: A

Stop



Item Name: Gusset Assembly

Start Date: 8/06/09 Start Qty: 6.00



Cust Item ID:

Required Date: 8/07/09 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

W

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3929

Rev A

6

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3929

Dwg Rev: *A*

Prog Rev: *A*

2-Deburr if necessary

IB 9-8-6

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

IB 9-8-6

6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____






NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			



NOTE: Date & initial all entries




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Page 2

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Start Date:	8/06/09	Start Qty: 6.00		Cust Item ID:		
Required Date:	8/07/09	Req'd Qty: 6.00		Customer:		
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00	SY 08/08/09			(46)	/		
130  Packaging Packaging	Pick Kit Memo	0.00 0.00	SY 09/08/07			(6x)			
140  Large Fab Large Fab	Weld bushings D3907-1 as per dwg D3929 316L rod batch: M109213 Memo	0.00 0.00	SY 09/08/07			(6x)			

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Page 3

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Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC9- Inspect visual per QSI004- Fusion Welds

0.00

QC

Memo

0.00

Quality Control

LPC 09-08-10

160

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

=> S or 10/10

(x6)

170

Identify as per dwg & Stock Location: Basket

0.00

Packaging

Memo

0.00

Packaging

PD 09-08-11

W/O:		WORK ORDER CHANGES					
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Page 4

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Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

PS-0812

C209108112

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Picklist Print

August 6, 2009 9:19:44 AM

Page 1

Work Order ID: 51170

Parent Item: D3929-041RevA

Parent Item Name: Gusset Assembly

Comments:

Start Date: 8/06/09

Required Date: 8/07/09

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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M304S11GA

Purchased

No

100

sf

86.1909

2.8421



304/316 0.125 Sheet



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

86.19090316

111018

86.1909032

D3907-1RevA

Manufactured

No

130

Each

28.0000

12.0000



Bushing



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

28

50944

28

111018

B386

24

SY 09/08/11

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

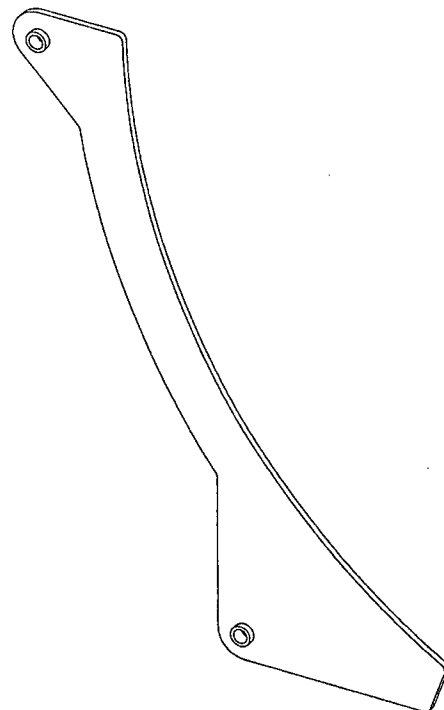
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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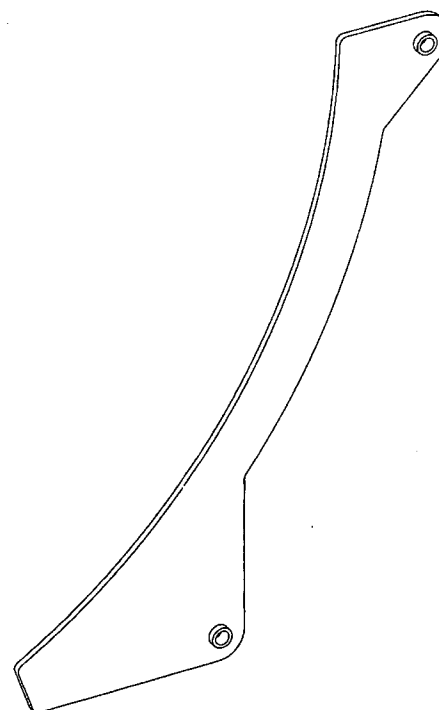
NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

ITEM	QTY -041	QTY -042	P/N	DESCRIPTION
1	X		D3929-041	GUSSET ASSEMBLY
2		X	D3929-042	GUSSET ASSEMBLY
11	2	2	D3907-1	BUSHING
12	1	1	D3929-1	SUPPORT GUSSET



D3929-041 GUSSET ASSEMBLY



D3929-042 GUSSET ASSEMBLY

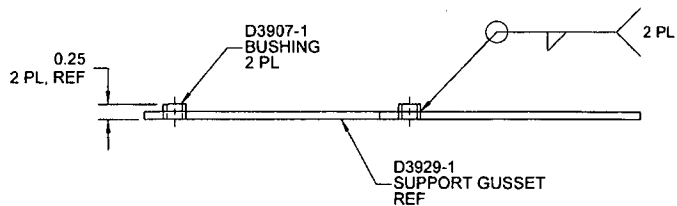
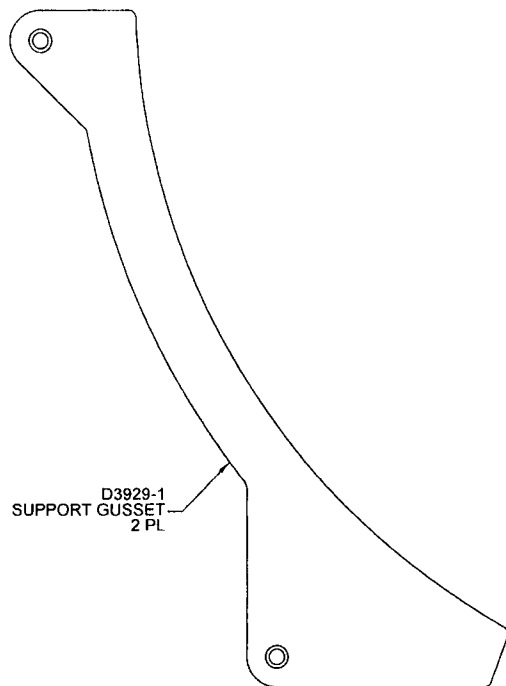
cd
5070

RELEASED
8/6/12

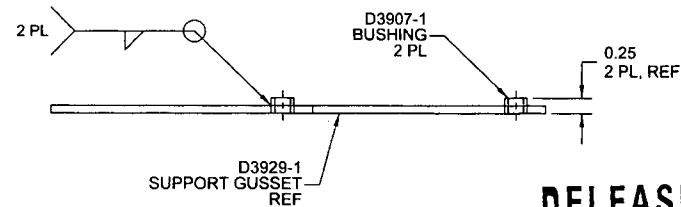
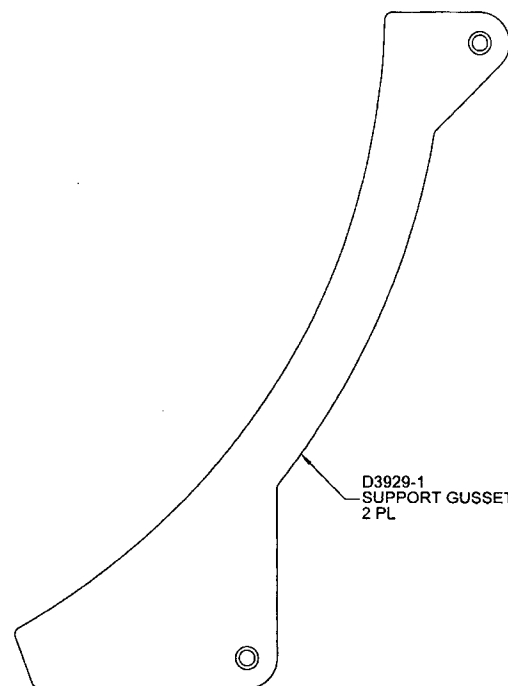
- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3929-04X" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 0.73 lbs EACH
 - 8) WELDING: PER DART QSI 004

A	NEW ISSUE	MB	09.04.03
REV.		BY	DATE
DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3929	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		GUSSET ASSEMBLY	NTS
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8 7 6 5 4 3 2 1



D3929-041 GUSSET ASSEMBLY



D3929-042 GUSSET ASSEMBLY

W/O 51170

RELEASED
09/04/2003

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3929	SHEET 2 OF 3
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